

Work Order ID 140743

Monday, January 18, 2016 8:10:25 AM

140743

Page 1

Item ID: D3278-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 1/18/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 1/29/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00

100

Bandsaw

SHEAR

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

40

0

DAS
40
9-89

16/01/18

104

0.00

104

Outsource5

Memo

0.00

Outsource process - Machining

ISSUE PO 31609
MACHINE PER DRWG D3278 REV.C

W

16.02.22

107

0.00

107

Packaging

Memo

0.00

Packaging

Receive & Inspect for Damage & Mat'l Certs

40

DAS
6
9-89

FEB 05 2016

Work Order ID 140743

Monday, January 18, 2016 8:10:25 AM

140743

Page 2

Item ID: D3278-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 1/18/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 1/29/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC5- Inspect part completeness to step on W/O	0.00							
125									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.01							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 3:10 OVEN TEMPERATURE:								
	FINISH TIME: 3:45								

DAS
38
9-89

FEB 05 2016

40 16-2-8

40 16-2-9 DAS 34 9-89

Work Order ID 140743

Monday, January 18, 2016 8:10:25 AM

140743

Page 3

Item ID: D3278-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 1/18/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 1/29/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						40x			16/02/10
QC	Memo	0.01							
Quality Control									
170	Identify as per dwg & Stock Location <u>GA</u>	0.00							
170						40x			16/02/10
Packaging	Memo	0.01							
Packaging	LOCATION : GA								
180	QC21- Final Inspection - Work Order Release	0.00							
180						MCJ			FEB 10 2016
QC	Memo	0.07							
Quality Control									

MCJ FEB 10 2016

Picklist Print

Monday, January 18, 2016 8:10:24 AM

Work Order ID: 140743

140743

Parent Item: D3278-2

D3278-2

Parent Item Name: Support

Start Date: 1/18/2016

Required Date: 1/29/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased		No		100	f	40.8120	0.2337	9.84			

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

16 / 01 / 18

**DAS
40
9-09**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	4.812	
M132546	2.76	
M132582	2.052	
MAT002	12	
→ M133889	12	
MAT003	24	
M133587	12	
M133699	12	

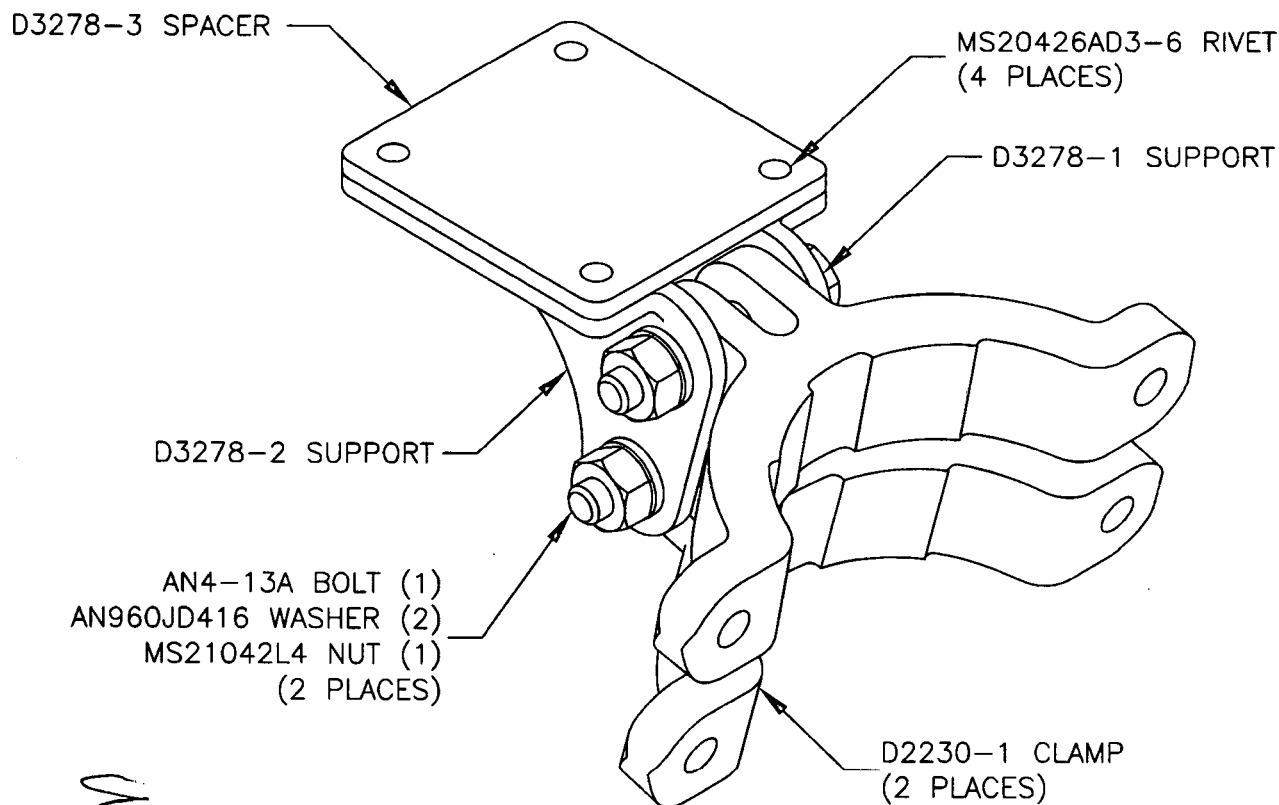
5.91



DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD - HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-26

D3278-041 SUPPORT ASSEMBLY



NO 140213

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

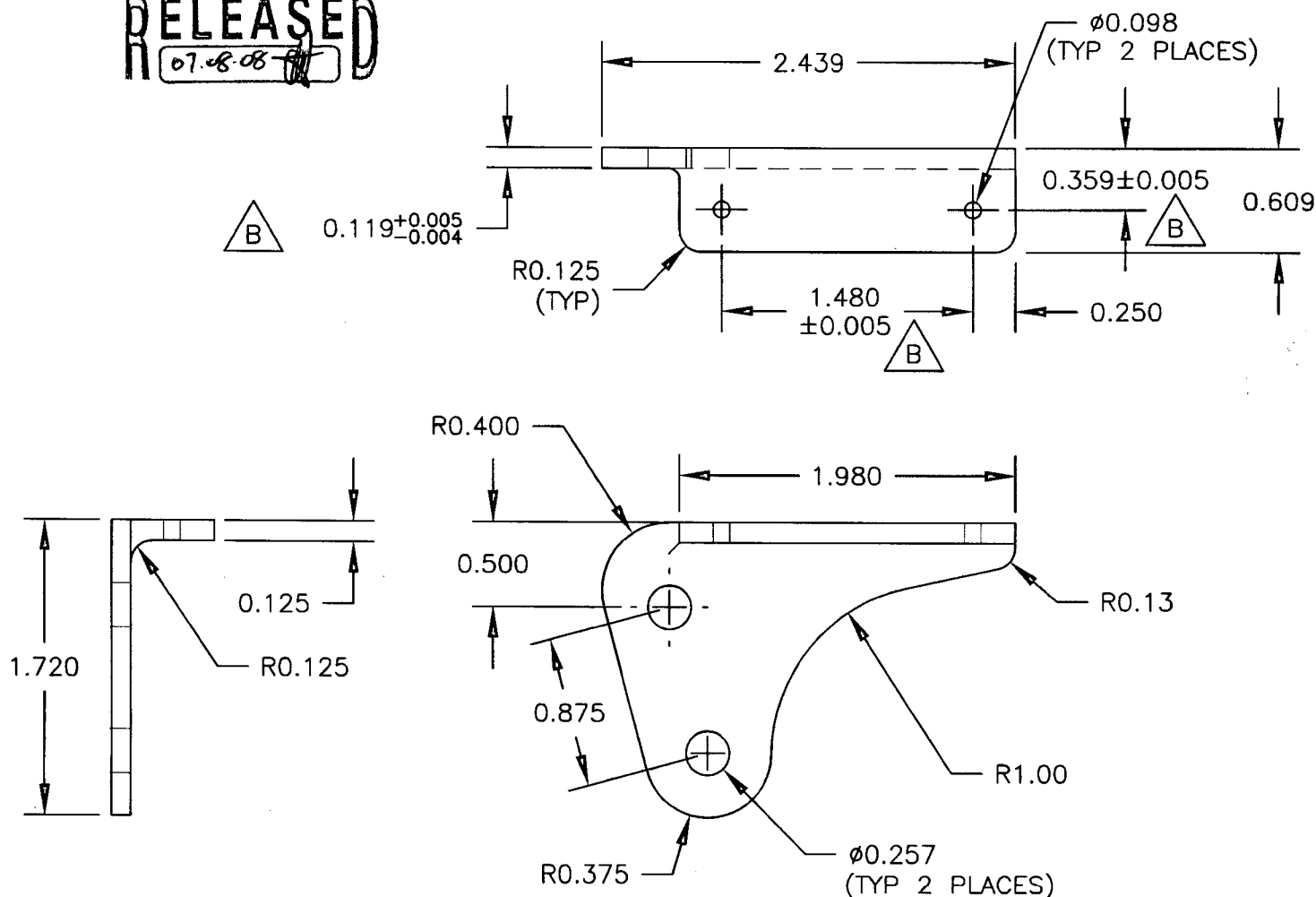
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CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

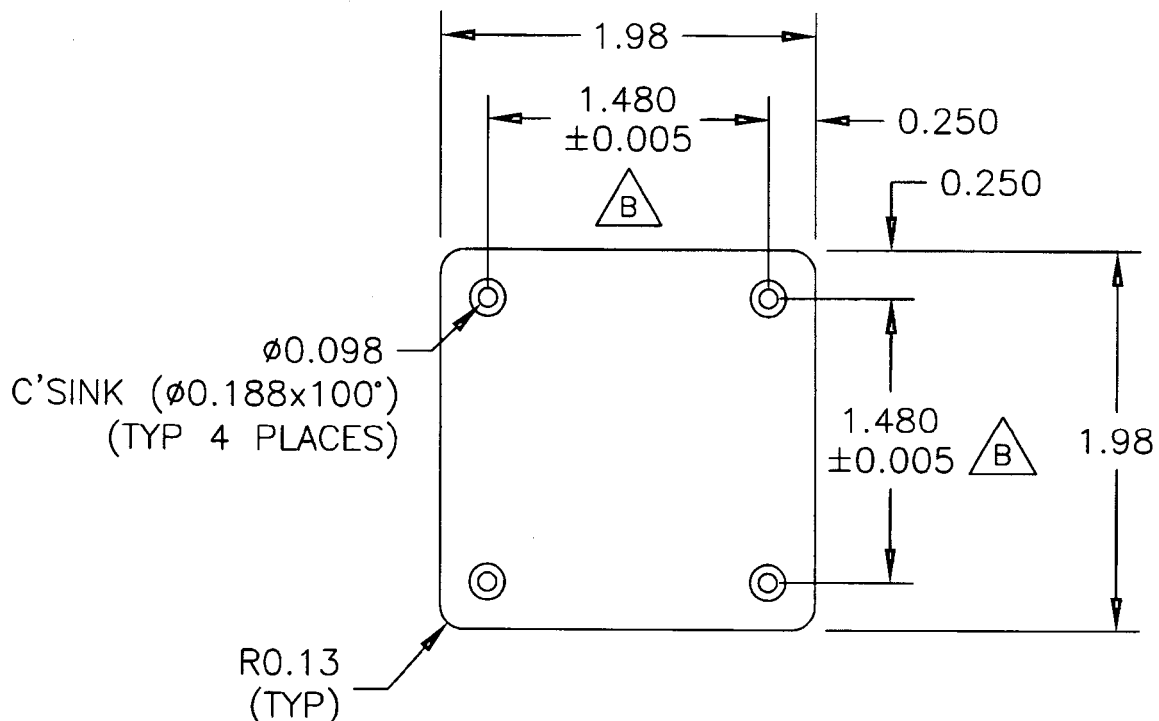
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DESIGN <i>qp</i>	DRAWN BY <i>bc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. - C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31109

Purchase Order Date 1/22/2016
PO Print Date 1/22/2016

Page Number 1 of 3

Order From :
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JAN 22 2016

Contact Name
Vendor Phone 613 678 3957

Buyer Linda Lacelle
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3278-1P MACHINE PER DRWG D3278 REV.C B140742	Support	2/15/2016 Yes 2/15/2016		40.00 Each	\$23.20	\$928.00
Line Total:							\$928.00
2	D3278-2P MACHINE PER DRWG D3278 REV.C B140743	Support	2/15/2016 Yes 2/15/2016		40.00 Each	\$23.20	\$928.00
Line Total:							\$928.00
3	D3137-3P MACHINE PER DRWG D3137 REV F B140744	Guide	2/15/2016 Yes 2/15/2016		100.00 Each	\$18.50	\$1,850.00

Note:

1/22/2016

Recd
1/12/13
SD



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21102
Date: Feb 05, 2016
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 31109	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Feb 05, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3278-1 Support	Each	40	40	
3278-2 Support, as per drawing D3278-2 Rev	Each	40	40	
3137-3 Bracket Assembly, as per drawing D3137 Rev ***1 piece scrap, 1 piece chipped corner no charge, pieces included in separate bag***	Each	100	98	
D3404-1 GHW LUGS, as per drawing Rev C	Each	40		40
4016-1 Basket Hinge, as per drawing 4016-1 Rev A	Each	40		40
4016-3 Basket Hinge, as per drawing 4016-3 Rev A	Each	60		60
3886-1 RevB Lug. as per drawing D3886 Rev	Each	40		40
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		